

Split

Work Order ID 127657-1

127657

Page 1

December-17-14 1:42:21 PM

Item ID: D4775-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut Assembly

Start Date: 12/26/14 Start Qty: 5.00

Required Date: 12/26/14 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MLSDate: 14-12-23

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4775

C

110

Pick Kit

0.00

110

Large Fab

Packaging

Memo

0.00

Packaging

24 FF JAN 12 2015

120

0.00

120

Small Fab

Memo

0.00

Small Fab

1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG

A/R PROSEAL BATCH: 17130090

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

24 FF JAN 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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December-17-14 1:42:20 PM

127657

D4775-041

Required Date: 12/26/14

Required Qty: 5.00

IPP

IPP REV:C

IPP REV:D 14.01.10

AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1		Manufactured	No			110	Each	4.0000	1	5			
D4775-1									**		FF	JAN 12 2015	
Strut Tube													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST514				4					
				126819				4		4			
D4777-1		Manufactured	No			110	Each	0.0000	1	5			
D4777-1									**		FF	JAN 12 2015	
Rod End Bearing													
				127480						4			
D4776-1		Manufactured	No			110	Each	4.0000	1	5			
D4776-1									**		FF	JAN 12 2015	
Basket Strut Clevis													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST126				4					
				121785				1		1			
				122550				3		3			
D4776-5		Manufactured	No			110	Each	0.0000	4	20			
D4776-5									**		FF	JAN 12 2015	
Spacer													
				V27743						16			

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Picklist Print

December-17-14 1:42:20 PM

Page 2

Work Order ID: 127657

127657

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 12/26/14

Required Date: 12/26/14

Start Qty: 5.00

Required Qty: 5.00

AN3-10A	Purchased	No	110	Each	218.0000	2	10	
AN3-10A						**		FF JAN 12 2015
Bolt								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	16	
m127817	16	
ST338a	200	
m130466	200	
ST349	2	
m128813	2	

MS21042L3	Purchased	No	110	Each	998.0000	2	10	
MS21042L3						**		FF JAN 12 2015
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	489	
M130922	489	
GA	33	
M128754	33	
ST305	473	
M130799	473	
ST307	3	
123900	3	

MS21209-F615	Purchased	No	110	Each	3.0000	1	5	
MS21209-F615						**		FF JAN 15 2015
Heli-Coil								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	3	
131270	3	
m130325	3	

DQA: _____ Date: _____



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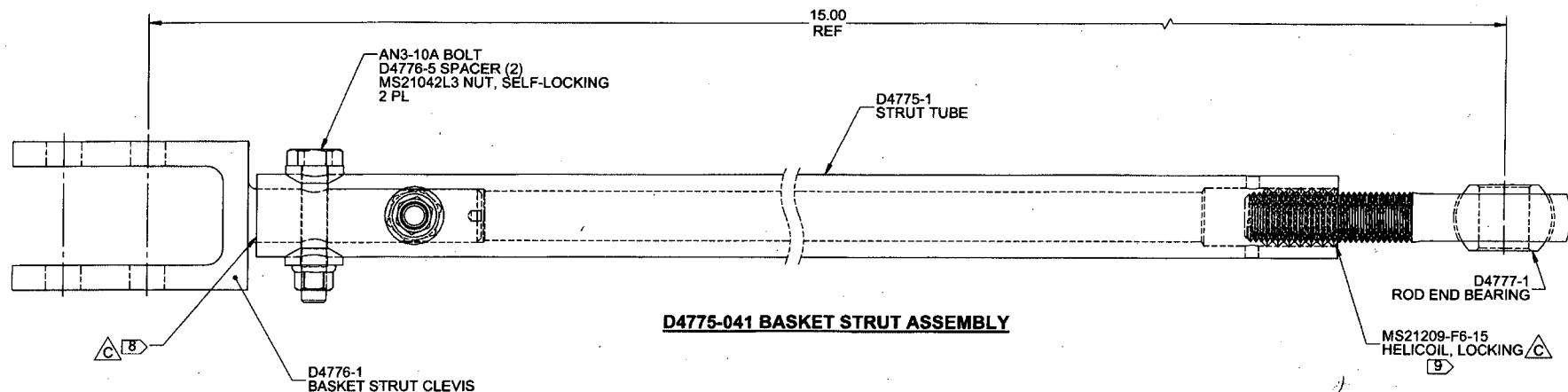
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ITEM	QTY	P/N	DESCRIPTION
	X	D4775-041	BASKET STRUT ASSEMBLY
1	1	D4775-1	STRUT TUBE
2	1	D4776-1	BASKET STRUT CLEVIS
3	4	D4776-5	SPACER
4	1	D4777-1	ROD END BEARING
5	2	AN3-10A	BOLT
6	2	MS21042L3	NUT, SELF-LOCKING
7	1	MS21209-F6-15	HELICOIL, LOCKING

SURE COPY
 RETURN TO
 EXISTING
 UNCONTROLLED COPY
 SUBJECT TO GOVERNMENT
 WITHIN 10 DAYS
 WITHIN 10 DAYS
 NO 127657 MLO
 14-12-23



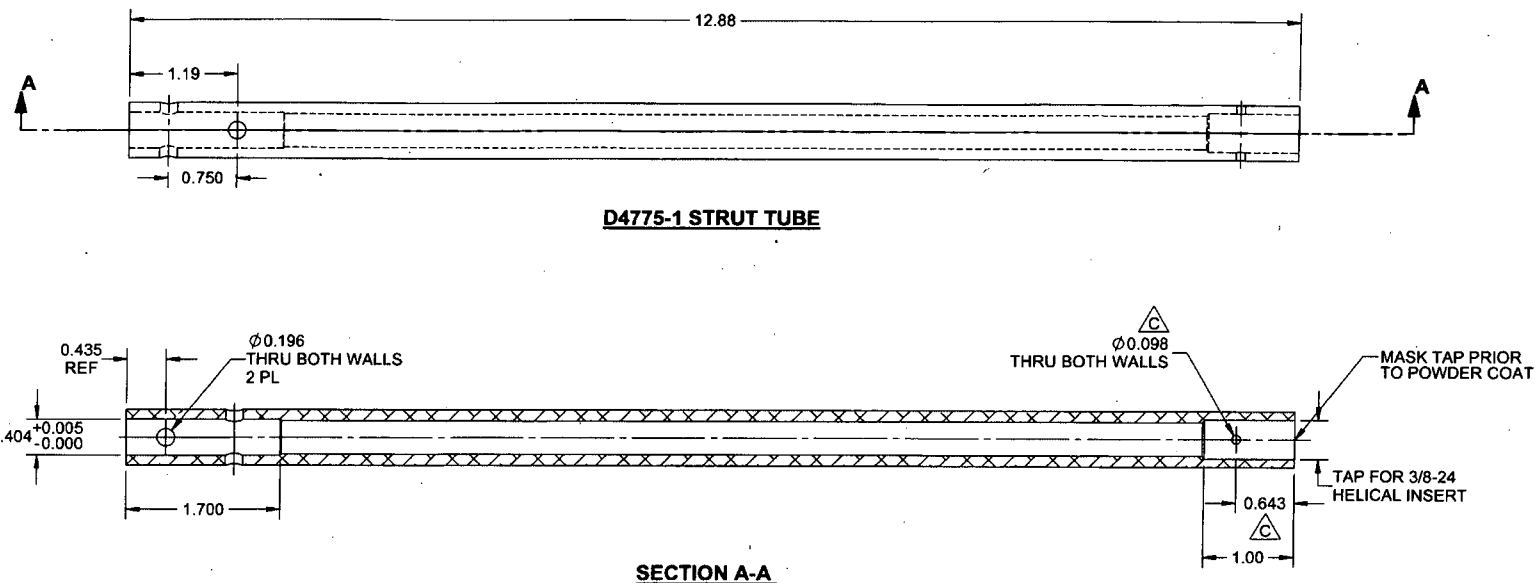
D4775-041 BASKET STRUT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.45 lbs
- 8) APPLY PROSEAL 890 B-2 (PRC) TO THE STEM OF ITEM 2 TO PREVENT RATTING.
- 9) ENSURE HELICOIL DOES NOT BLOCK HOLE

RELEASED
 2014-01-07

C	ITEM 7 WAS F6-20, B2-2 Ø0.098 "WITNESS HOLE" ADDED. REASON: CUSTOMER FEEDBACK. ADDED NOTE 8. REASON: DESIGN IMPROVEMENT.	AJS	13.11.01
B	DELETED WELD PINS (-3) REPLACED WITH FASTENERS. REASON: PREVENT CRACKING & EASE OF MANUFACTURE. C6-2 HOLE PATTERN ON -1 REVERSED TO ENSURE FASTENERS CLEAR STRUCTURE. FINISH NOTE MOVED TO -1 (SHEET 2).	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT ASSEMBLY	NTS
DATE	13.11.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4775-1 STRUT TUBE

SECTION A-A

RELEASED
2014-01-08

NOTES:

- 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING, $\phi 0.625 \times 0.125$ WALL
PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
OR AMS 4080 OR AMS 4082 OR AMS 4083
OR ASTM B210 OR ASTM B241
REF DART SPEC M6061T6T0.625W0.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT ASSEMBLY	NTS
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